

Date: Monday, 22/12/2008 3:05:40 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSY
Job Number : 44237	
Estimate Number : 13541	
P.O. Number :	Part Number : D3307041
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3307 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42729	Material :
Written By :	Due Date : 20/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>DD 08.12.23</u>	
Comment : Est: A 08.08.05 New issue EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.2600 sf(s)/Unit Total : 1.0400 sf(s)

304/316 .032 Sheet

batch: 109057IB 9-1-5

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut D3307-1 as per Dwg D3307

Dwg Rev: AProg Rev: AIB 9-1-5(7)

2-Deburr if necessary

IB 9-1-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-1-5**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 09/01/05 (+7)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

bend as per dwg D3307

09/01/13 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/01/2009 1:09:04 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASS'Y
 Job Number : 44237
 Estimate Number : 13541
 P.O. Number :
 This Issue : 13/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 22/12/2008 Type : SMALL /MED FAB
 Previous Run : 42729
 Part Number : D3307041
 Drawing Number : D3307 REV. A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 20/01/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: A 08.08.05 New issue EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D33073 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
 Gasket B42762 (4x) B44725 (3x)

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond gasket as per dwg D3307

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 177

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

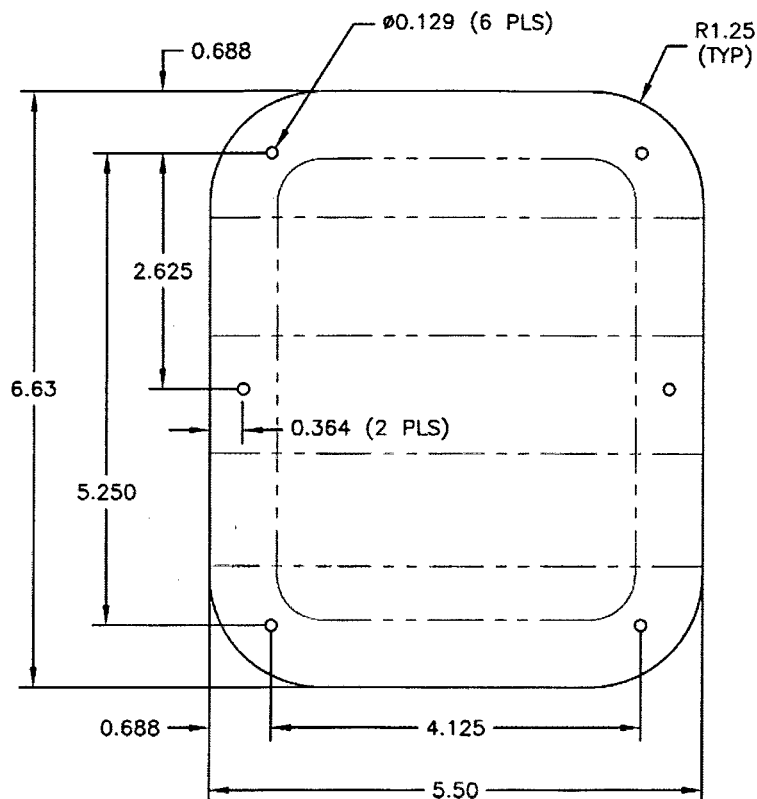
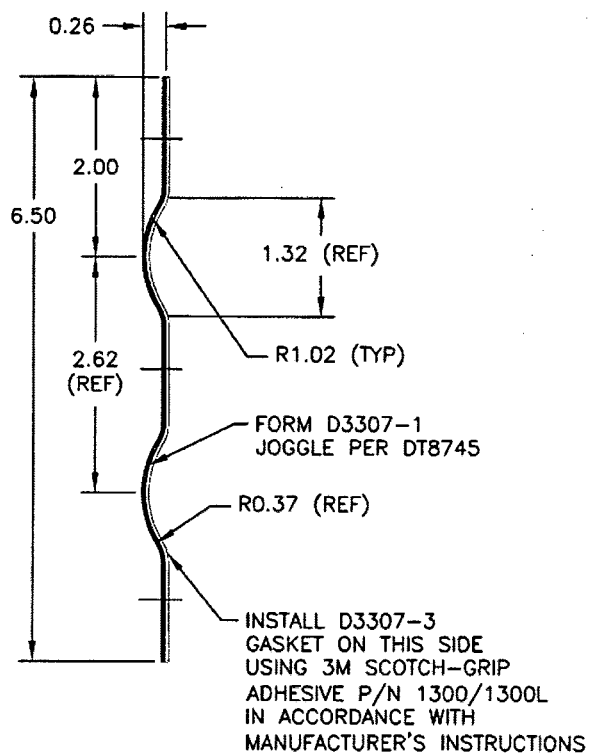
Job Completion



MF
09-02-10

DART

DESIGN 13	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 14	APPROVED 15	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18**D3307-1 PANEL FLAT PATTERN****D3307-041 BEND DETAIL**

IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

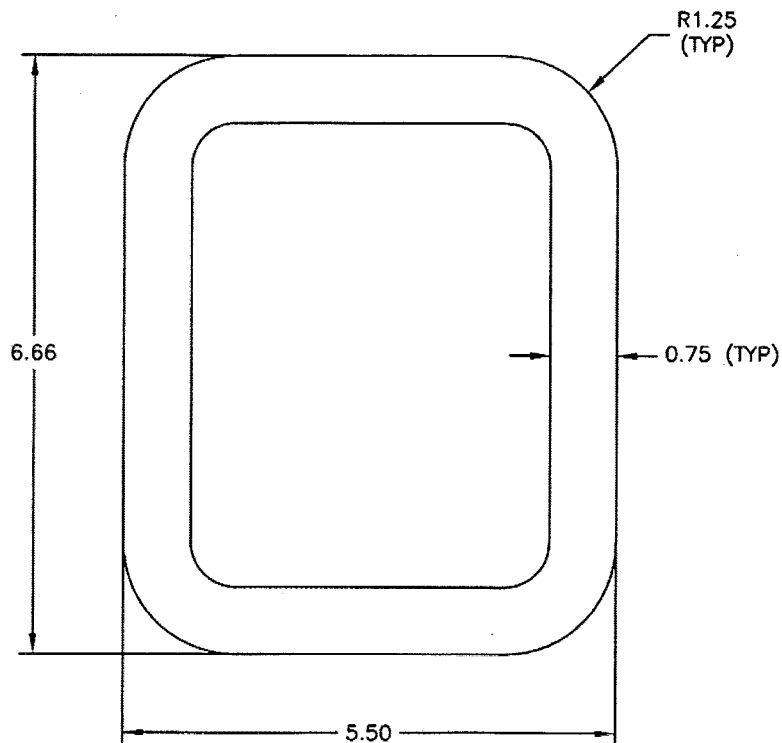
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
05.01.18 [Signature]**D3307-3 GASKET****D3307-3 NOTES:**

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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